


Date: Wednesday, 17/09/2008 11:39:50 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COMFORT SEAT- FRAME	
Job Number : 42057		
Estimate Number : 13369		
P.O. Number :	Part Number : D37521	FOR ENGINEERING USE ONLY
This Issue : 17/09/2008 S.O. No. :	Drawing Number : D3752 PROTOTYPE 08.09.16	<b>PROTOTYPE</b>
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : R&D THERMOFORMING	Drawing Revision : PROTO	
Previous Run : 39728	Material :	
Written By : 	Due Date : 24/09/2008	Qty: 4 Um: Each
Checked & Approved By :		
Comment : Est. REV: A New Issue 08.06.03 DL verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3752-1  
 Set up clamping frame as per folio

*Wh* 08.09.16

2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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SABIC



Comment: Qty.: 10.6670 sf(s)/Unit Total : 42.6680 sf(s)  
 GE PLASTICS LEXAN SHEET

Batch # M105330

*X4*  
*Wh* 08.09.16

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*Wh* 08.09.16

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3752 and Folio

Dwg. Rev. B.  
 Folio Rev. B.

*X4*  
*Wh* 08.09.16

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT - FRAME

Job Number: 42057

Part Number: D37521

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

24  
Sh. 08.09.16

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

PTO →  
x2.  
Sh. 08.09.16

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/09/16 x2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 08.09.17 x2

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

N/A FOR ENG USE ONLY

CP 08.09.17 x2

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Prototype only.  
08/09/18

Job Completion








00079

08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3752-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

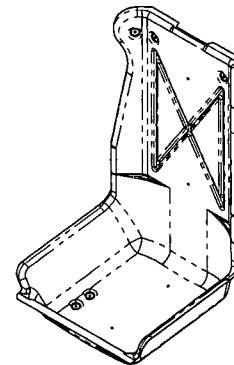
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>42057</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.09.16	6.	2 UNITS UNEVEN HEAT	 08.09.17 pc QSI 042	Scrap 2 units	 08.09.16	 08.09.18	 08.09.17 72 QSI 042	 08.09.18

NOTE: Date & initial all entries

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

08.09.16



ENSURE MATERIAL IN  
THIS AREA IS OPAQUE  
WITH A CONTINUOUS  
TEXTURE

0.035 MIN THICKNESS  
AT THIS HOLE

0.050 MIN THICKNESS  
AT THIS HOLE

15.0±0.5

5.0±0.5

LOCATION OF 1.92" LONG CRACK FROM GRINDING

0.050 MIN THICKNESS  
ALONG TOP EDGE

0.100 MIN THICKNESS  
AT THIS HOLE

5.0±0.5

0.090 MIN THICKNESS  
AT THIS HOLE

18.0±0.5

HEAVY HAIRCELL  
TEXTURE ON  
THIS SIDE

0.030 MIN THICKNESS  
IN THIS AREA (CORNER)

0.060 MIN THICKNESS  
ALONG BOTTOM EDGE

18.2 REF






18.0 REF

31.5 REF

### D3752-1 SEAT FRAME

#### NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

B	FRONT PORTION NOW SHORTER (B5-1). 18.0 WAS 19.6 (C4-1). 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.09	DRAWING NO. D3752	REV. SHEET 1 OF 1
		TITLE SEAT FRAME	SCALE NT
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## Receiving Report

Date: 07/08/16 Batch No: M105330  
 Supplier: G.E. Polymerships Dart P/O: 4161

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☐ No ☒ N/A ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection in H0012 N/A ☒  
 Work Order                      N/A ☒

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK)                      Level 12                     

Production/Admin:                       
 Date: 07/08/16  
 Received/Costing: RIP 5411  
 Initial: CZ

Location                     

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

\*\* PLEASE NOTE: IF YOU WOULD LIKE TO HAVE  
 FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS  
 INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION\*\*  
 THANK YOU  
 EMAIL/FAX INFO



Attn: CENTAL

**GE Polymershapes**

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER : PO00004161

OUR SHIPPER NO: 078178

LINE ITEM # .1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 125 X 48 X 96







THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25. 853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

JON CALDWELL  
BRANCH MANAGER

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.09.30	N/A	GRIND TO REDUCE THICKNESS UNIFORMLY AROUND PART.  " IDENTIFY "FOR TESTING"	 080930		1	 08.09.30 pu Q51042	N/A 	
08.09.30	N/A	QCS AFTER GRINDING		08.09.30	1	 08.09.30 pu Q51042	N/A 	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



